

1652

16



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-C
Job Sheet 170587



DAS
21
9-89

678

ASN

Part No: RBE350A94-3700-C

Job Qty: 8 ea

Part Name: Swashplate Immobilizing Tool Adjustable Brace



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/17/18

Job Tracking No:

Due Date: 5/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		5/28/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	6 pcs		5/28/18	0.00	1.50	Small Fab-3		MCC DAS
120	QC	6 pcs		5/28/18	0.00	0.00	QC5		38
130	Packaging	6 pcs		5/28/18	0.00	0.00	Packaging3-1		50 9-89
140	QC21-SA	6 Ea		5/28/18	0.00	0.00	QC21		DAS 21 9-89 180620

Part Op 110 - -Bag and tag 3 RBE350A94-3700-C-1A per kit as per DWG sheet 1
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-C-1A	Adjustable Brace Assembly	18 Ea (3 ea)	90-Start up Operation	5081298

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE350A94-3700-C-1A	18	0	0

173924

Part Specifications

Specifications could not be found.

Plex 6/19/18 9:11 AM dart.logan.david



Container No: S082402



Part: RBE350A94-3700-C

Job No: 170587

Serial No/Batch: S082402

Revision 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/19/18



Container No: S082402



Swashplate Immobilizing Tool Adjustable Brace

PART NO: RBE350A94-3700-C

Serial No/Batch: S082402

Revision:

Operation:

Change No:

Packaging

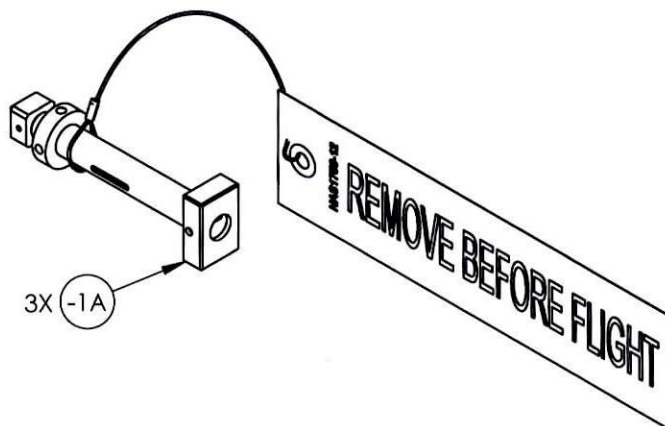
Mfg Date: 06/19/18

Job No: 170587

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	7/10/2015		
4A		CH'D T/N WAS RBEA94-3700-C IS RBE350A94-3700-C, DELETED ASSY. FROM TOOL NAME.	10/23/2013	CFS	RW
5	15-0213	-01 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187. -03 CH'D HOLE WAS Ø3.1 mm IS Ø.129 - .125. CH'D DIM WAS Ø.315 S.F. -07 IS Ø.3159 - .3150. -05 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187. -07 CH'D HOLE WAS Ø3 mm IS .129 - .125. CH'D DIM WAS Ø.315 S.F. -03 IS Ø.3170 - .3164 ∇ .36.	8/14/2015	RJC	JAG
6	16-0286	-1A ADDED DRAWING. -01, -03, -09 -01 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -C DELETED. -01 CH'D DIM WAS Ø.620 S.F. -03 IS Ø.634 (S.F. -03), WAS .250 IS .250 +.000/- .005, WAS .130 THRU IS .132 +.010/- .000 (S.F. -11), WAS Ø.192/.187 THRU IS Ø.192/.187 THRU ALL (P.F. -13), DELETED DIM Ø.750 ∇ .47 MIN S.F. -05, ADDED DIM Ø.747/.742 (S.F. -05), .49, 2X FULL R. -03 CH'D DIM WAS Ø.3159/.3150 IS Ø.3159/.3155 (S.F. -07), WAS .217 IS .217 +.005/- .000, WAS 2X Ø.129/.125 THRU IS 2X Ø.129/.125 THRU ALL (P.F. -11). -05 CH'D DIM WAS Ø.625 THRU ALL $\square$ Ø.750 ∇ .473 S.F. -01 IS Ø.63 THRU ALL $\square$ Ø.755/.750 ∇ .473 (S.F. -01), WAS Ø.192/.187 THRU ALL IS Ø.192/.187 THRU ALL (P.F. -13), WAS .217 IS .217 +.000/- .010. -07 CH'D DIM WAS Ø.3170/.3164 ∇ .36 IS Ø.3170/.3164 ∇ .37 (S.F. -03), WAS Ø.129/.125 THRU IS Ø.129/.125 THRU ALL (P.F. -11), WAS .217 IS .217 +.000/- .005, WAS .551 IS .55. -09 CH'D DIM WAS .20 IS 2X .20. ADDED -15, -17, -19.	2/28/2017	RJC	SM



NOTE:

CROSS REFERENCE NUMBERS:
 RED BARN No.'s = HELIPRODUCTS NO.'s
 RBE350A94-3700-C-01 = E-350A94-3700-25
 RBE350A94-3700-C-03 = E-350A94-3700-26
 RBE350A94-3700-C-05 = E-350A94-3700-27
 RBE350A94-3700-C-07 = E-350A94-3700-28
 FOR REFERENCE ONLY.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3				2
	1		-01		TUBE	STEEL		3
	1		-03		ALL THREAD	B7 STEEL		4
	1		-05		BOTTOM	6061		5
	1		-07		TOP	6061		6
	1		-09		KNURLED NUT	STRESS PROOF		7
	2	B/O	-11		SLOTTED SPRING PIN	S.S.	Ø1/8 X 3/4 (MCMaster-CARR #92373A181)	2
	1	B/O	-13		SLOTTED SPRING PIN	S.S.	Ø3/16 X 1 (MCMaster-CARR #92373A251)	2
	1	B/O	-15		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	2	B/O	-17		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	1	B/O	-19		LANYARD CABLE	COATED STEEL	Ø1/16 X 8 (CARR LANE #CL-2-C)	2
	ASSY -1A							

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C	
REV 6	
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:8	DATE 8/21/2016 SHEET 1 OF 7